

1 5/30

SPLIT

DART AEROSPACE LTD		Work Order:	23718 A
Description: Wheel Assembly		Part Number:	D3233-041
Dwg: D3233 Rev. B		Qty:	29
Ref:		Page 1 of 1	

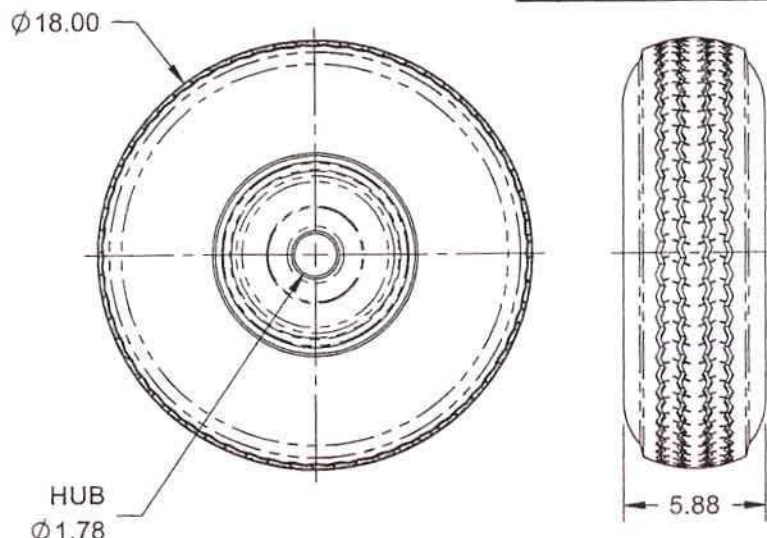
Step	Location	Procedure	By	Date	Qty																												
1	DC	Issue Traveler																															
2	MFA	Pick: <table border="1"> <thead> <tr> <th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr> </thead> <tbody> <tr> <td>21</td><td>D3233-7</td><td>Shaft Sleeve</td><td>823002</td></tr> <tr> <td>21</td><td>D3233-9</td><td>Tire & Rim Assembly</td><td>823726</td></tr> <tr> <td>21</td><td>D3233-5</td><td>Hub Sleeve</td><td>823001B</td></tr> <tr> <td>42</td><td>NKI 30/20</td><td>Bearing & Inner Sleeve</td><td>M17346</td></tr> <tr> <td>84</td><td>Shim Stock</td><td>0.004" thick Brass Shim Stock</td><td>M17370</td></tr> <tr> <td>42</td><td>35x45x7</td><td>Axel Seal</td><td>M17346 M17019</td></tr> </tbody> </table> or CR 35x45x7 HMS4 R	Qty	Part Number	Description	Batch	21	D3233-7	Shaft Sleeve	823002	21	D3233-9	Tire & Rim Assembly	823726	21	D3233-5	Hub Sleeve	823001B	42	NKI 30/20	Bearing & Inner Sleeve	M17346	84	Shim Stock	0.004" thick Brass Shim Stock	M17370	42	35x45x7	Axel Seal	M17346 M17019			9
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3	MFA	Press out bearings that are supplied with D3233-9 wheel and discard them.	CPL	05-07-11	9																												
4	MFA	Cut shims and assemble as per Dwg D3233	CPL	05-07-11	9																												
5	MFA	Spray inside hub and bearing with LPS-3 & block hole with a clean dry rag for storage.	CPL	05-07-11	9																												
6	QC5	Inspect work to Step 5		05-07-11	9																												
7	ST	Identify and Stock	CPL	05-07-11	9																												
8	AC	Cost / part: 160.13																															
9	DC	Close W/O 160.12 Inspect Level 21	SUR	05-08-02	9																												
				05/07/12	9																												

Rev	Date	Change	Revised By	Approved
A	05.01.12	New issue	KJ/JLM	
B	05.03.03	Made in house	KJ/JLM	

RELEASED
05/03/15



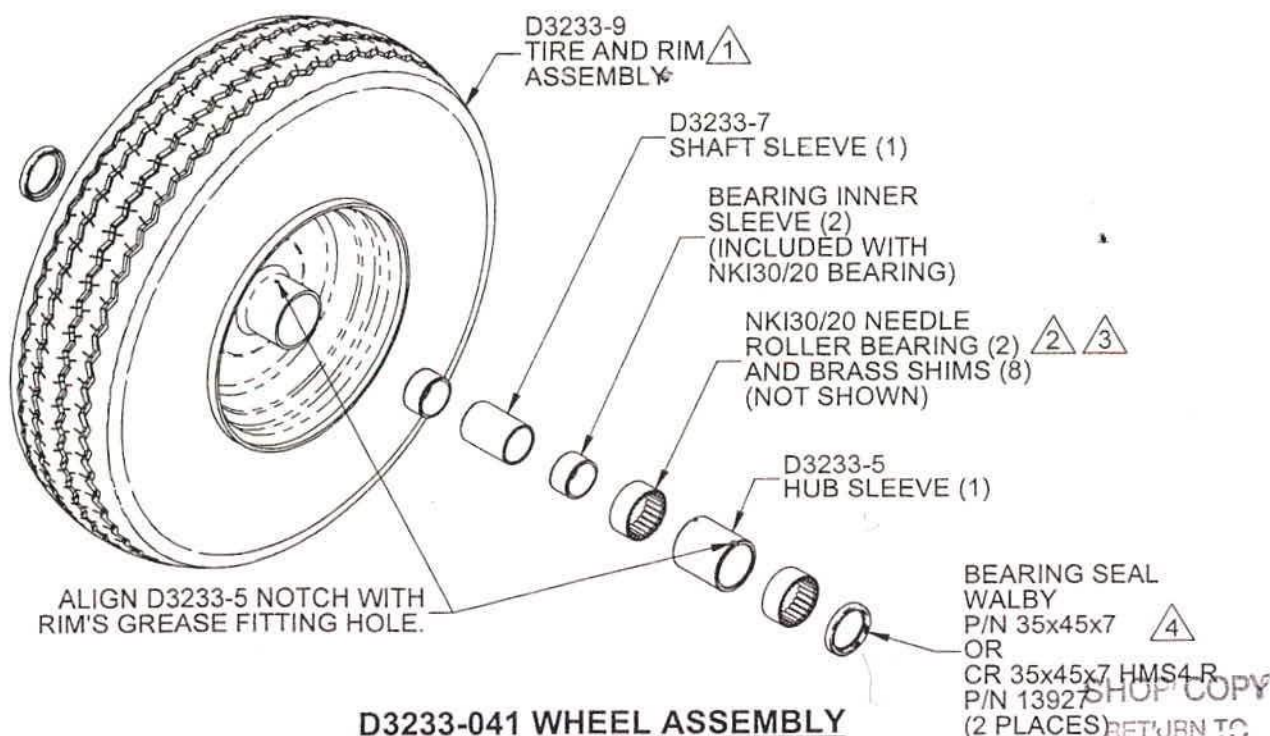
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 1 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1
A	05.02.18	NEW ISSUE	
B	05.03.08	ADDED BEARING SEALS	



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05/05/04

WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: 19.0 x 5.8 RIM: 5.70 x 8.0	910 LBS (RANGE C)	90 PSI*

* MANUFACTURER'S RECOMENDATIONS ARE 75 PSI FOR HIGH SPEED USE.



D3233-041 WHEEL ASSEMBLY

NOTES:

- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 8353T74
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 3) PRESS FIT NEEDLE ROLLER BEARINGS INTO RIM HUB WITH (4) 0.5 X 0.75 X 0.004 BRASS SHIMS PER BEARING, (1) AT EACH QUADRANT.
- 4) POSSIBLE SUPPLIER: GENERAL BEARING
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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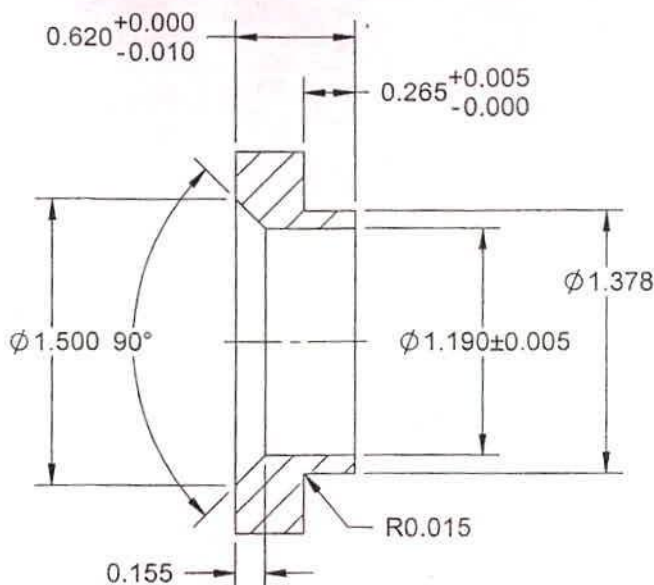
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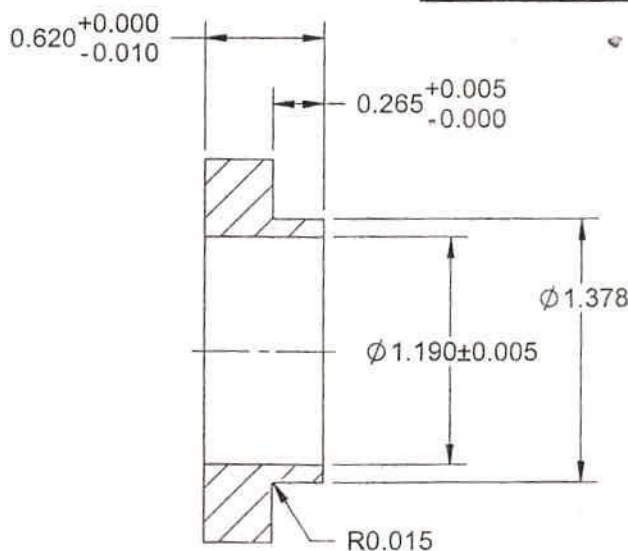
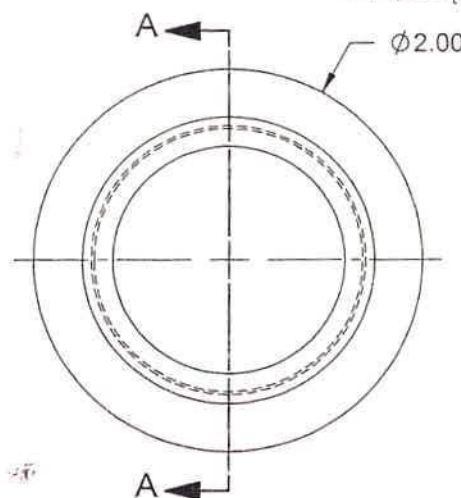


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DATE 05.03.08	TITLE WHEEL ASSEMBLY		SCALE 1:1



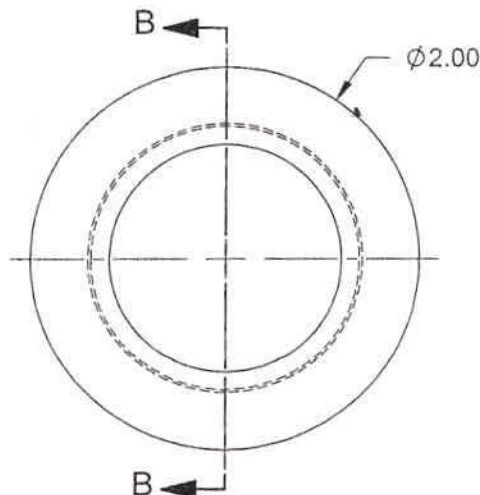
SECTION A-A

D3233-1 INSIDE WASHER



SECTION B-B

D3233-3 OUTSIDE WASHER



NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS
(REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER

NO. 23718

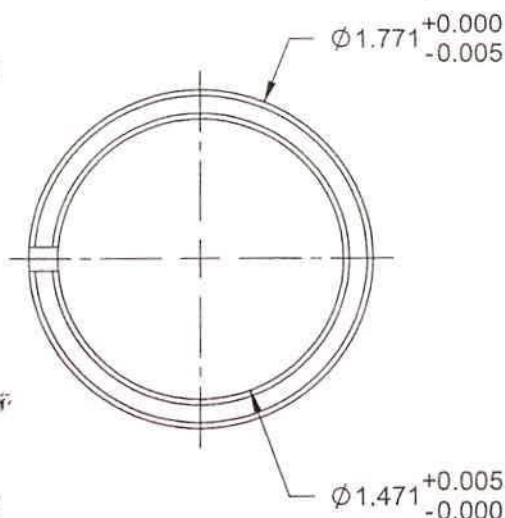
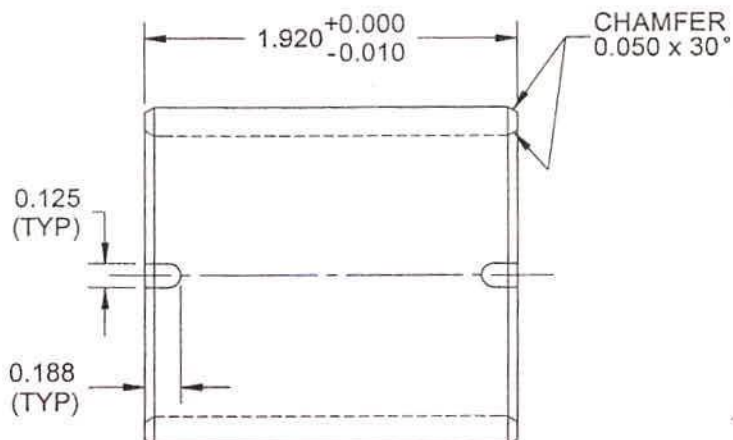
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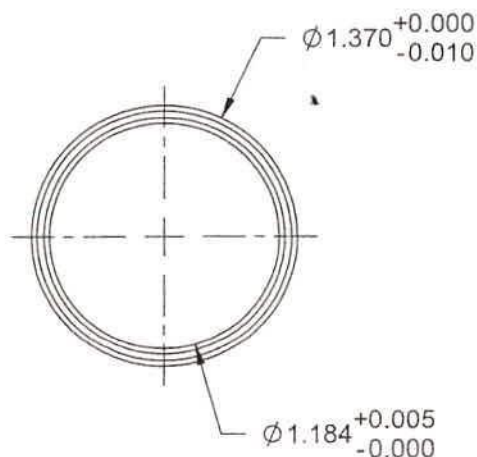
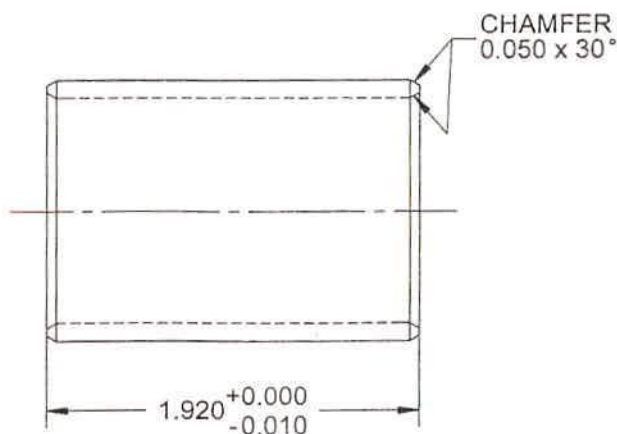


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 3 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1

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05/05/04



D3233-5 HUB SLEEVE



D3233-7 SHAFT SLEEVE

NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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